



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB910-0003-1
Job Sheet 169224



Part No: RB910-0003-1

Job Qty: 3 ea

Part Name: Quill



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/5/17

Job Tracking No:

Due Date: 12/7/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Customer: Bell Helicopter Miami Inc (CEDWA04)

PO Box 3689 Bristol, TN, 37625 USA ph:(954) 491-5071

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		11/20/17	0.00	0.00	Start Up Machining-4		11-17-12-7
110	CNC Lathe	3 pcs		11/21/17	0.00	3.00	MORI SL-154		11
120	QC	3 pcs		11/21/17	0.00	0.00	QC2		11
130	QC	3 pcs		11/21/17	0.00	0.00	QC8		11-17-12-7
140	QC	3 pcs		11/21/17	0.00	0.00	QC5		3-88
150	Outsource	3 pcs		12/7/17			ATG001-VC	10	11-17-12-7
160	Packaging	3 pcs		12/7/17	0.00	0.00	Packaging2		11-17-12-7
170	QC	3 pcs		12/7/17	0.00	0.00	QC6		3-88
180	Packaging	3 pcs		12/7/17	0.00	0.00	Packaging3		3-88
190	QC21-SA	3 Ea		12/7/17	0.00	0.00	QC21		3-88

Part Op 110 - 1-Machine as per DWG. FB654 FOLIO REV: _____ DWG REV: _____ 2-Deburr

Descriptions: 140 - Engrave T/N and S/N number Using Marktronic engraver as per DWG.

150 - Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As Per DWG RB910-0003-1 Rev. 5

JAN 18 2016

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6R1.000	1	49	0	0

5008424

1.17

Part Specifications

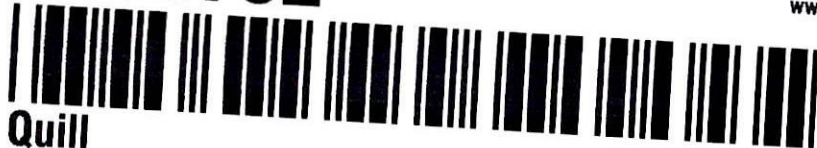
Specifications could not be found.

Plex 12/7/17 12:35 PM Dart.lajeunesse.marie

018-186



S018792



Quill

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA

TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

PART NO:

RB910-0003-1

Revision:

Operation:

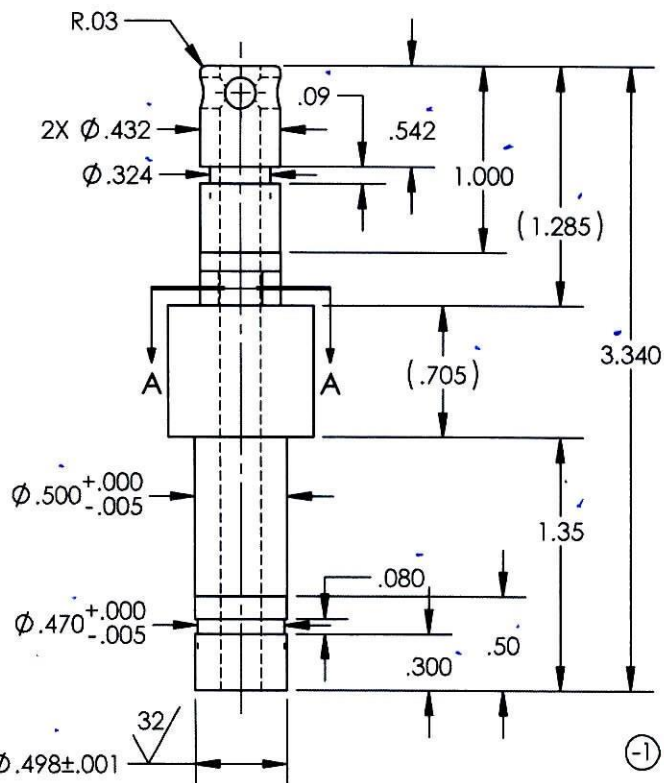
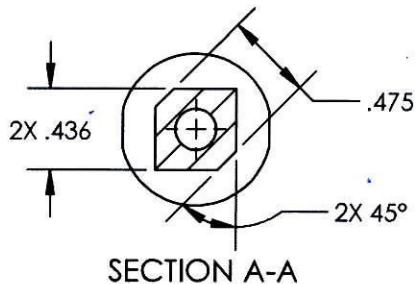
Change No:

Start up Operation

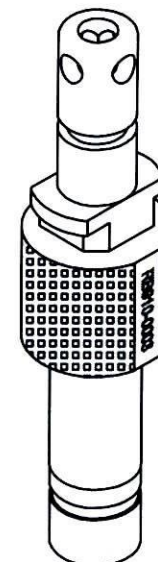
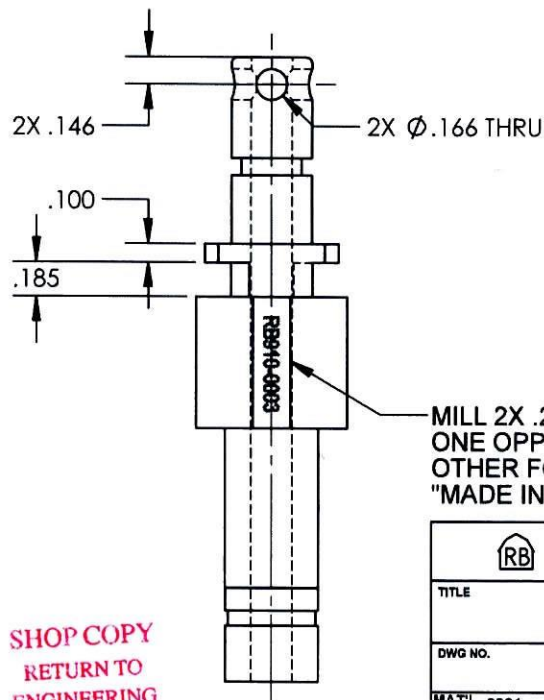
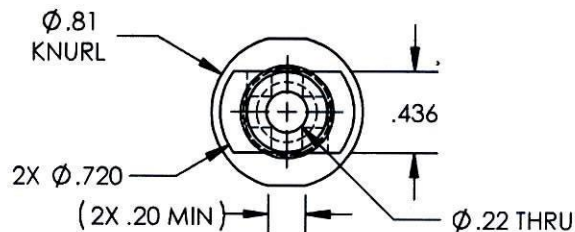
Mfg Date: 12/07/17

Job No: 169224

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	SHORTENED LATCH FROM .125 TO .100	9/12/06	WP	
2	CHANGED P/N FROM HF090806, & ADDED FLAT FOR P/N	9/21/06	WP	
3	IMPLEMENTED NEW DWG. FORMAT, CONDENSED DIMS., AND ADDED ASSEMBLY VIEW. ALSO REDUCED -1 FROM THREE HOSE RIBS TO ONE.	5/20/08	WP	
4	CHD -1 CALL OUT FROM MILL A .188 FLAT FOR P/N .081 TEXT PER G.E.	7/27/11	RJC	
5	-1 MODIFIED TO USE -9 COUPLING. CH'D DIM ON FLATS WAS .188 IS (2X .20 MIN). CH'D HOLE WAS Ø.25 ± .198 IS Ø.22 THRU. ADDED (1.285) DIM. CH'D LATCH WIDTH WAS .432 IS .436. CH'D DIMS ON SECTION A-A WAS .100 X 45° IS 2X 45° DELETED .617.	1/24/2014	DPD	GE



① UNCONTROLLED COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

QUILL

16922-1 MJS
17-12-05

RED BARN MACHINE	
TITLE T/R GEARBOX TOOL	
DWG NO. RB910-0003-1	REV 5
MAT'L 6061	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weill</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH BLACK ANODIZE
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC MIL-A-8625F, TYPE II, CLASS II
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL BELL 430
SCALE 1:1	DATE 9/7/2006
SHEET 2 OF 2	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					



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PURCHASE ORDER PO038682

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			649.5200 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required							
14	168254	646.3814	Wiper Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed	1/17/18	4 pcs	0 pcs	4 pcs	\$7.10/pcs	\$28.40
15	169450	647.0310	Channel Issue P/O to ATG: Hard Anodize Black / Prime as per Dwg 647.0300	Firmed	1/17/18	30 pcs	0 pcs	30 pcs	\$12.10/pcs	\$363.00
16	169391	647.7823	Cross Bracket Aft Issue P/O to ATG:	Firmed	12/22/17	10 pcs	0 pcs	10 pcs	\$12.25/pcs	\$122.50
Line Item Note RUSH										
17	169009	RBT18601	Main Rotor Swashplate ReGreasing Tool -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2 Water seal -Certificate of Conformity is required	Firmed	1/17/18	6 pcs	0 pcs	6 pcs	\$26.00/pcs	\$156.00
18	169224	RB910-0003-1	Quill -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant As Per DWG RB910- 0003-1 Rev. 5	Firmed	1/17/18	3 pcs	0 pcs	3 pcs	\$6.20/pcs	\$18.60
19	169418	RBD29936	Tail Rotor Bungee Tool -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity	Firmed	1/17/18	3 pcs	0 pcs	3 pcs	\$6.20/pcs	\$18.60



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914404

Date: 11-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
3 ea	Part: RB910-0003-1 Quill Black Anodize per MIL-A-8625F, Type II, Class 2, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22206		Rev: 5 PO: PO038682 Line: 18
6 ea	Part: RBD29936 Tail Rotor Bungee Tool Black Anodize per MIL-A-8625F, Type II, Class 2, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22207		Rev: PO: PO038682 Line: 19
5 ea	Part: D2055 Clamp Black Anodize per MIL-A-8625F, Type II, Class 2, .0004-.0010" (.4 - 1 mils). Job: 22209		Rev: D PO: PO038682 Line: 21
1 ea	Part: RBW109-3101-58-2-3 Hammer Head Clear Anodize per MIL-A-8625F, Type II, Class 1, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22218		Rev: 3 PO: PO038682 Line: 30
3 ea	Part: RBT102103-5 Retainer Clear Anodize per MIL-A-8625F, Type II, Class 1, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22219		Rev: C PO: PO038682 Line: 31
2 ea	Part: RBT102103-3 Adapter Clear Anodize per MIL-A-8625F, Type II, Class 1, .0004-.0010" (.4 - 1 mils), Water		Rev: C Made in Canada.



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Fax: (613) 446-4556

Pack List

Number: 914404

Date: 11-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Sealant Job: 22221	PO: P0038682	Line: 33
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>11/21/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>Quinn Burt</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			